

Work Order ID 87196

July-11-12 10:08:52 AM

87196

Page 1

Item ID: D350-604-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rear Locker Extender
 Start Date: 7/16/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/24/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2273	F
D350-604-041	B

100 ***100*** DOCUMENT CONTROL 0.00
 DC Memo 0.00
 Document Control Photocopy bluefile and create labels per PPP D350-604-041
 CHG003 for D2273 rev.E (new gelcoat)
 CHG004 for D2273 rev.F (new primer)

110 ***110*** PURCHASING 0.00
 Purchasing Memo 0.00
 Purchasing Issue P/O: 17542
 Description: D350-604-041 Rear locker extender.
 Supplier: Delastek.
 Certification of Conformity and process sheet from Delastek is required.
 4 x 2600-6 Camlock stud - Ship to Delastek B 122441
 4 x 2600-LW Retaining washers - Ship to Delastek B 122452

Handwritten: For MJS 12-7-31

Handwritten: 120726

Handwritten: 120726

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87196

87196

Page 2

July-11-12 10:08:52 AM

Item ID: D350-604-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rear Locker Extender

Start Date: 7/16/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/24/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging	Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control	Check hole locations to template. DT 8824 Check process sheet and audit.								
140		0.00							
140									
Small Fab	Memo	0.00							
Small Fab	INSTALL DECALS AS PER DWG								

11/27/31 (1)

*test fitted on 350 helicopter
DAC 16 8-8 12/2/31*





Pro 2

? 12/31/11 (1)

Dart Aerospace Ltd

W/O: 87196		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-601-041 PAR #: _____ Fault Category: DWG NCR: Yes No DQA: Yes Date: 12/08/15
 Resolution: _____ Disposition: Rework QA: N/C Closed: Yes Date: 12/08/20

NCR: 12-1690		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/7/31	100	Beam locker was received in from supplier not primed Re. not called us on Dwg. RC/ SUPPLIER	 ASZ005 12/7/31	Prime As ^{outside} per drawing and per ASZ005	m/ 12.07.31	 12/7/31	 ASZ002 12/6/31	 12/6/31

NOTE: Date & initial all entries

Work Order ID 87196***87196***

Page 3

July-11-12 10:08:52 AM

Item ID: D350-604-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rear Locker Extender

Start Date: 7/16/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/24/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 <i>0.00 DTS 16 176040</i>							
160 *160* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D350-604-041 Location: _____ PPP Rev: _____	0.00 0.00							<i>12/8/12</i>
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>12/8/12</i>

MCS 12/08/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-11-12 10:08:51 AM

Page 1

Work Order ID: 87196

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 7/16/12

Required Date: 8/24/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R 12.02.07 AS PER ECN12-
521 DD verf:JLM IPP REV:S 12.04.04 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-6 Camlock Stud		Purchased	No			110	Each	199.0000	4	4		BS 122441 12-07-26	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST380		199							
				120077		8							
				121556		4							
				122317		42							
				122335		145							
2600-LW Camloc Retaining Washer		Purchased	No			110	Each	319.0000	4	4		BS 122452 12-07-26	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST380		316							
				121524		116							
				122317		200							
				ST381		1							
				121287		1							
				ST398		2							
				120648		2							
D2268 Decal		Manufactured	No			140	Each	31.0000	1	1		12/17/12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST007		20							
				80010		20							
				ST009		11							
				69592		2							
				78908		9							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-11-12 10:08:52 AM

Page 2

Work Order ID: 87196

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 7/16/12

Required Date: 8/24/12

Start Qty: 1.00

Required Qty: 1.00

D2269 Manufactured No Each 25.0000

1

Decal

Location	Loc Qty	Loc Code
ST007	20	
80011	20	
ST009	5	
78920	5	

D350-604-041P

Rear Locker Extender

Purchased

No

110

Each

0.0000

1

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

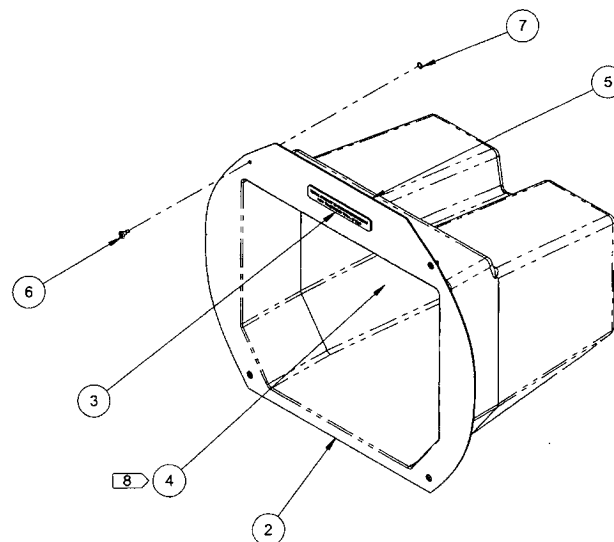
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D350-604-041	REAR LOCKER EXTENDER ASSEMBLY
2	1	D2273	REAR LOCKER EXTENDER
3	1	D2268	PLACARD
4	1	D2728-1	PLACARD
5	1	D2729-1	PART ID LABEL
6	4	2600-6	CAMLOCK STUD
7	4	2600-LW	RETAINING WASHER



D350-604-041 REAR LOCKER EXTENDER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 PART ID LABEL
- 7) WEIGHT: 7.75 lbs
- 8) INSTALL D2728-1 PLACARD IN DEPRESSION ON INSIDE BACK WALL
- 9) PLACARDS TO BE ORIENTED TO MATCH "UP" ORIENTATION OF RLE

B	INCORPORATE DSI 9470 (ZN D7-1), UPDATE DWG TO CURRENT STANDARDS. ADD D2728-1 PLACARD AND ORIENTATION NOTE (ZN C3-1). ADD D2729-1 (ZN C5-1).	DC	12.02.07
A	NEW ISSUE	CP	02.04.01
REV	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	D350-604-041	SHEET 1 OF 1
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	RLE ASSY	NTS
DATE	12.02.07	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO17542**

Purchase Order Date 7/26/12

PO Print Date 7/26/12

Page Number 1 of 1

Order From :

VU-STE002

STEALTH COMPOSITES INC.
3 NORTH COLUMBUS BLVD.
PHILADELPHIA, PHILADELPHIA PA 19106
USA

Contact Name		Buyer	Linda Lacelle
Vendor Phone	215-919-7584	Requisition Nbr	
Vendor Fax	215-689-4979	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 10
		Currency	USD
		FOB	Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
	0589-604-041P	Rear Locker Extender	8/02/12 Yes	1.00 Each	FedEx PI collect	\$750.0000	\$750.00

PO Total: \$750.00

Change Nbr: 1

Change Date: 7/26/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO

Sheet1

Stealth Composites Inc.

Process Data Sheet

Date: 07/26/12
Client: DART
Job: Prototype
Comments: Stealth spec locker 2 ply flange

Part Name: Stealth spec extended locker
Part Number: prototype
Revision: n/a
Material: fiberglass/FR polyester resin
Quantity: 1

Resin: Hetrion FR 650 T-20
Gelcoat: G730AA1100
Catalyst: Cadox M-50A
Fiber: 1.5 oz random fiberglass mat

Batch: 0001291211
Batch: G31
Batch: 12041F0701

Setup: Operation: n/a
Mold Prep: clean with dry cloth
Material prep: Cut fiberglass to fit mold
Mix gelcoat: Catalyze gelcoat @1.5% Cadox
Apply gelcoat: Spray mixed gelcoat onto mold
Mix resin: Catalyze resin @1.5% Cadox
Apply Fibers: apply cut fiberglass mat to mold
Apply Resin: Saturate fibers with resin
Cure time: 24 hrs
Demold: remove locker from mold
Trim: cut and sand flange per drawing
Drill holes: 4 holes drilled per drawing

Date	Initial
7/26	JAD
7/26	JAD
7/27	JAD
7/27	JAD
7/27	JAD
7/27	JAD
7/27	JAD
7/27	JAD
7/28	JAD
7/30	JAD
7/30	JAD
7/30	JAD

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

****Certificate of Conformity****

Customer:

Dart Aerospace

Purchase Order #:

P017542

Packing Slip #:

Part #:

DKC134-0081

Serial #:

Prototype

Description:

Stealth spec 2 ply flange locker

Quantity:

1

Certification:

We hereby certify that:

1. The above the listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications;
2. All work was accomplished in accordance with the Dart Aerospace Purchase Order;
3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

Authority:

APPROVAL:

Signature:

Title: President

DATE:

7/30/2012

8/2/12/31

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

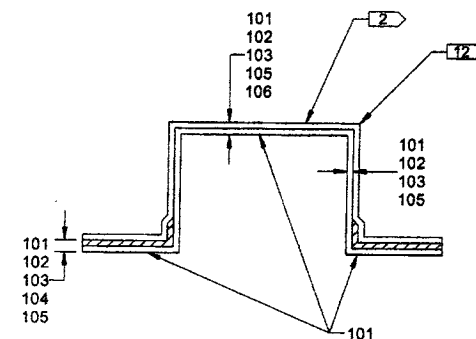
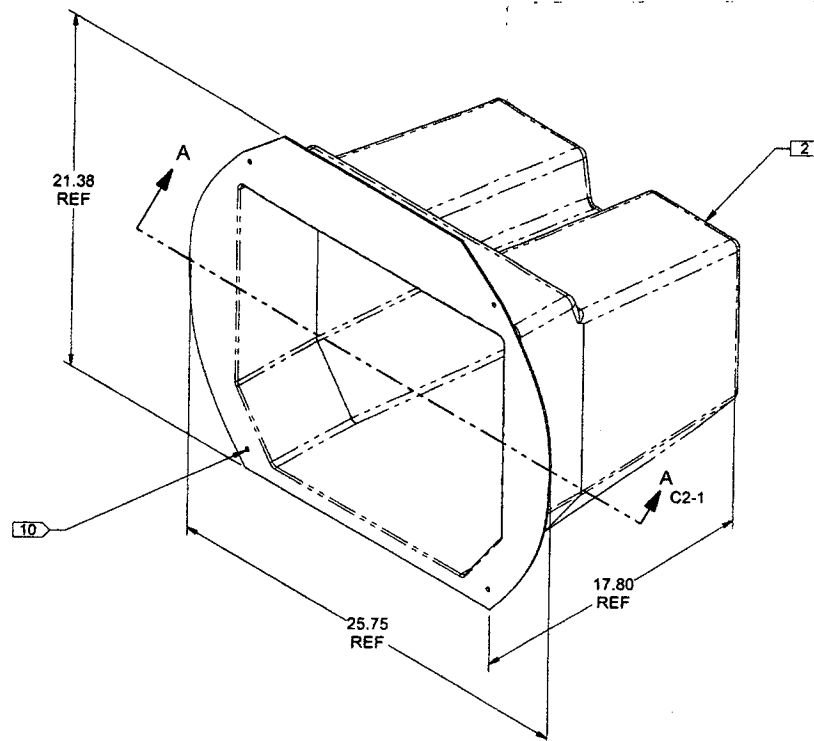
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
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<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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SECTION A-A
C4-1

RELEASED
2012-03-29

D2273 REAR LOCKER EXTENDER

NOTES:

(1) MATERIALS:

RESIN: DERAKANE 470-36/411/510A40
FIBRE: 9 oz = 9.7 oz 7781 WEAVE "S" GLASS
18 oz = 18.0 oz ROVING "E" GLASS

(2) FINISH: FINISH THIS SURFACE WITH DUPONT GREY PRIMER LE 3404-S/LE 1175-S Δ

(3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

(4) UNITS: INCHES UNLESS OTHERWISE NOTED

(5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

(6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1

(7) WEIGHT: 7.75 lbs

(8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.

(9) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACCUUM

(10) TRIM & DRILL PER DT8020. OPEN HOLES TO \varnothing 0.257 (4 PLACES)

(11) CONSTRUCTION:

- 101-WHITE GLOSS GELCOAT # GEL 2330PAWK745 TO MIN THICKNESS OF 0.020
- 102-9 oz ALL OVER
- 103-18 oz ALL OVER
- 104-18 oz REINFORCE FRONT FLANGE EXTENDING 2" ON SIDES
- 105-9 oz ALL OVER
- 106-PEEL PLY

(12) MATTE TO HOLD DOWN CORNERS AS REQUIRED

F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A8-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 844W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	88.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BC	DRAWING NO.	REV. F
MFG. APPR.	BC	D2273	SHEET 1 OF 1
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	350 REAR LOCKER EXTENDER	NTS
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